

Date: Tuesday, 3/11/2008 7:57:43 AM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	STEP EXTRUSION		
Job Number	37754			Part Number	D2622120C		
Estimate Number	10058			Drawing Number	D2622 REV C1		
P.O. Number				Project Number	N/A		
This Issue	3/11/2008	S.O. No.		Drawing Revision	C1		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	PURCHASED PARTS	Due Date	4/4/2008	Qty:	120
Previous Run	36923			Um:	Each		
Written By	<i>AJ</i>						
Checked & Approved By	<i>AJ 08/03/11</i>						
Comment	Est. A 02.11.12 New Issue KJ/RF						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
Comment: PURCHASING Issue P/O: <i>5903</i> <i>CLO8/03/12</i> a) Extrude as per Dwg D2622 Rev. C b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 38 ksi e) Minimum elongation = 8% f) Order at 120" longg) Bon L Canada Inc. tool # 897123 Rev. A h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required		
2.0	D2622120CP	Extrusion
Comment: Qty.: 1.0000 Each(s)/Unit Total : 120.0000 Each(s) Extrusion		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached		
4.0	QC6	DIMENSIONAL CHECK
Comment: DIMENSIONAL CHECK Inspect dimension per Dwg D2622 Check Pull test per Dwg D2622 for compliance page attached Check hardness with Webster tester		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:57:44 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP EXTRUSION

Job Number: 37754

Part Number: D2622120C

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: HALL 003

ZT

08-03-28

K126

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



UMF

08-03-28

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

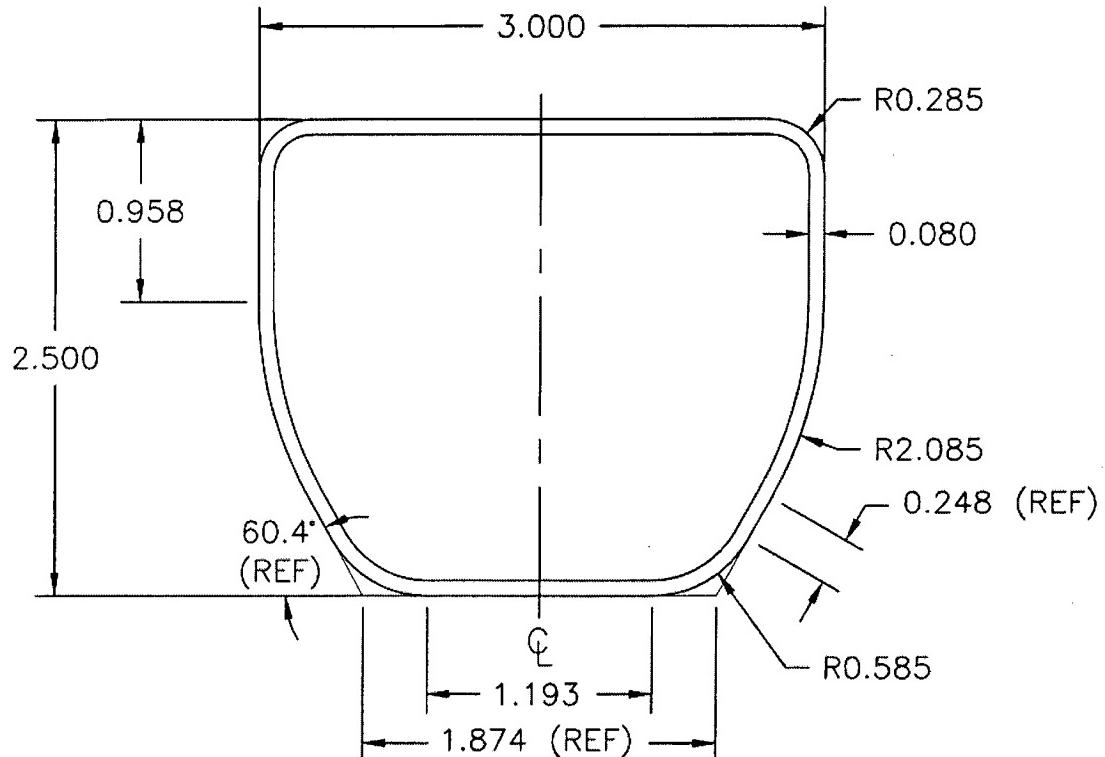
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



COPY RELEASED
02.09.11

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2622
		REV. C
		SHEET 1 OF 1
DATE	TITLE	SCALE
02.09.11	STEP EXTRUSION	1:1
A	96.11.29	NEW ISSUE
B	97.12.12	CHANGE MATERIAL, ADD TOL. QSI
C	02.09.11	0.080 WAS 0.085; ADD PART & DIE No.
CI	CP 02.10.04	ADD 'REV. A' TO DIE NUMBER.



D2622-XXX STEP EXTRUSION

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 REV. A
- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
 MINIMUM ELONGATION = 8%

- 5) PART IS SYMMETRIC ABOUT CENTERLINE
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 37754



Canada

ACCT# 00046024

SHIP TO
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON
K6A 1K7 CN

PHONE 613-632-5200

SOLD TO / PURCHASER
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON
K6A 1K7 CN

PHONE 613-632-5200

INVOICING COMPANY AND LOCATION
SIGNATURE ALUMINUM CANADA
500 EDWARD AVENUE
RICHMOND HILL ON L4C 4Y9

TERMS / FREIGHT
O / P

REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCE

MANIFEST DATE	03-24-08
MANIFEST NUMBER	638042
SALES ORDER NUMBER	27644

CREDIT REP HAMBROOK, PAU 905-508-3250	SALES REP
Kutter A 450-435-6551	Burton D 905-427-2227

JOB	BILL OF LADING NUMBER 08375792
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ITEM NO.	ORIGINAL ORDER QUANTITY	UNIT	PREVIOUS SHIPPED QUANTITY	MFG. PART NUMBER CUSTOMER PART NUMBER	ALLOY & TEMPER		FINISH DESCRIPTION		THIS SHIPMENT			UNIT	QUANTITY DUE		
					LENGTH		FABRICATION DESCRIPTION		NBR OF PKGS	GROSS POUNDS	NET QUANTITY				
					CUTTING TOLERANCE		SHIPPING TOLERANCE								
02	121	KG M PC	0 0 0	DAA-897123-1 D2622	6061 /T6 120" +3/16 " -0 "		MILL CERTIFICATE OF COMP (+015-015, 0139-0102)		2	546	526 384.05 126	KG M PC	0 0 0		
				LOT/TKT DETAIL:			27644020 / 186853 27644020 / 186854		1 1	218 328	208 318	50 PC 76 PC	126		

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.

No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

PAGE 1

2	546	526 384.05 126	KG M PC
TOTALS			



CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

Cust. Date	Cust. No.	Sales Order	Page
03/24/08	175019	27644	1
Cust. PO	B/L No.	Lot	Date
5903	08375792	27644020	3/24/08

Ship To	Ship To
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No.	Part No.	Item Description	Cust. Part
2.000	DAA-897123-1	120" Mill 6061 T6	D2622
Gross Weight	546 KGS		
Net Wt.	526 KG	126 PC	384 M
Specification	AMS-QQ-A-200/8 & ASTM B221-06		

Mechanical Tests:

Test	Tensile	Yield	%Elongation	Conductivity	Bend/ Drift	HREW
No.	MPA / KSI	MPA / KSI				

1	320.7 / 46.5	284.9 / 41.3	10.4	.0	94
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Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
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.65	.29	.28	.08	.87	.06	.006	.08	.000	.011	.02	.000	.00
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This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

D. VanBakel, QA Manager Signature Aluminum Canada Inc